

What is claimed is:

1. An abrasive machine,
comprising:
an upper abrasive plate rotating to abrade an upper face of a work piece, said upper abrasive plate having a plurality of slurry holes for feeding slurry to the work piece;
a lower abrasive plate rotating to abrade a lower face of the work piece, said lower abrasive plate sandwiching the work piece with said upper abrasive plate so as to abrade the both faces of the work piece;
a slurry feeding unit pressurizing and feeding the slurry;
a plurality of slurry paths respectively connecting the slurry holes to said slurry feeding unit;
a plurality of valve mechanisms being respectively provided to said slurry paths so as to control flows of the slurry; and
a control section for controlling said valve mechanisms.
2. The abrasive machine according to claim 1,
wherein said control section controls degree of opening said valve mechanisms so as to control feeding the slurry to each of the slurry holes.
3. The abrasive machine according to claim 1,
wherein said slurry feeding unit is a pressurizing unit capable of feeding the slurry with fixed pressure,
said pressurizing unit is connected to the slurry holes by a distributor,
and
said valve mechanisms are electromagnetic valves.
4. The abrasive machine according to claim 1,

further comprising:

a carrier having a through-hole in which the work piece is set so as to abrade the both faces of the work piece, said carrier being provided between said upper abrasive plate and said lower abrasive plate;

a carrier holder holding an outer edge of said carrier; and

a crank mechanism for orbiting said carrier holder.

5. The abrasive machine according to claim 4,

further comprising:

a shaft being connected to said upper abrasive plate;

a rotating mechanism for rotating said shaft; and

a slurry feeding tube being provided in said shaft,

wherein said slurry paths are connecting tubes respectively connecting the slurry holes to said slurry feeding tube.

6. The abrasive machine according to claim 5,

wherein said shaft includes a water path for feeding water for cooling said upper abrasive plate.

7. The abrasive machine according to claim 1,

further comprising:

a carrier having a through-hole in which the work piece is set so as to abrade the both faces of the work piece, said carrier being provided between said upper abrasive plate and said lower abrasive plate;

a sun gear engaging with an outer edge of said carrier; and

an internal gear engaging with the outer edge of said carrier,

wherein said carrier spins and orbits along said internal gear.

8. The abrasive machine according to claim 7,

further comprising:

a supporting plate being provided to said upper abrasive plate, said supporting plate supporting a distributor; and

a plurality of connecting tubes respectively connecting the slurry holes to said distributor.

9. A method of abrading a work piece in a machine comprising:

an upper abrasive plate rotating to abrade an upper face of a work piece, said upper abrasive plate having a plurality of slurry holes for feeding slurry to the work piece;

a lower abrasive plate rotating to abrade a lower face of the work piece, said lower abrasive plate sandwiching the work piece with said upper abrasive plate so as to abrade the both faces of the work piece;

a slurry feeding unit pressurizing and feeding the slurry;

a plurality of slurry paths respectively connecting the slurry holes to said slurry feeding unit;

a plurality of valve mechanisms respectively provided to said slurry paths so as to control flows of the slurry; and

a control section for controlling said valve mechanisms, said control section controlling said valve mechanisms so as to control amount of the slurry fed from said slurry feeding unit to each of the slurry holes while abrading the work piece.

10. The method according to claim 9,

wherein said control section feeds the slurry via the selected slurry hole so as to remove the work piece from said upper abrasive plate by liquid pressure when said upper abrasive plate is moved away from said lower abrasive plate.